

Work Order ID 67172

Wednesday, March 09, 2011 12:54:24 PM



Page 1

Item ID:	D500-572-011	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Bearpaw					
Start Date:	3/9/2011	Start Qty: 2.00		Cust Item ID:		
Required Date:	3/16/2011	Req'd Qty: 2.00		Customer:		
Reference:						

Approvals:	Process Plan:		Date:	11-03-9	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D2435	Rev E1
IIND500-572	RevA

100		0.00							
	DOCUMENT CONTROL								
DC	Memo	0.00							
Document Control	Photocopy bluefile and create labels per PPP D500-572-011 CHG005								
									BG 11-3-22
160	Pick Kit	0.00							
Packaging	Memo	0.00							
Packaging									
									11/3/22 (20)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Item ID: D500-572-011

Accept

Setup Start

Revision ID:

Stop

Item Name: Bearpaw

Start Date: 3/9/2011 Start Qty: 2.00

Cust Item ID:

Required Date: 3/16/2011 Req'd Qty: 2.00

Customer:






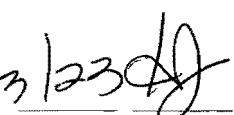
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170  QC Quality Control	QC4- 100% Inspect kits for completeness Memo	0.00 0.00							
180  Packaging Packaging	Packaging Memo Identify and pack for shipping as per PPPD500-572-011 Location: <u>B</u> <u>PCA</u>	0.00 0.00				<u>11/3/22</u>			
190  QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00					<u>11/3/23</u>		 <u>MF</u> <u>11-03-22</u>

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Picklist Print

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Work Order ID: 67172

Parent Item: D500-572-011

Parent Item Name: Bearpaw



Start Date: 3/9/2011

Required Date: 3/16/2011

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:C 04.02.17 Blank size changed KJ/JLM
 IPP Rev:D 07-01-02 Was K10007 JLM
 IPP Rev:E 08-01-09 Added Step 2 JLM Verified By:EC
 IPP Rev:F 08-10-15 New Manufacturing Method JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
QS200-M44S Clamp		Purchased	No			120	Each	37.0000	2	4			

Location	Loc Qty	Loc Code
ST450	37	
115410	5	
115589	14	
115621	6	
116857	12	

AN4-15A Bolt		Purchased	No			170	Each	330.0000	8	16			
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Location	Loc Qty	Loc Code
ST308	316	
116786	316	
ST358	14	
114784	9	
115108	5	

AN960JD416 Washer	NAS1149D0463J	Purchased	No			170	Each	30.0000	8	16			
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Location	Loc Qty	Loc Code
ST300	24	
113288	24	
ST356	6	
115622	6	

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Page 2

Work Order ID: 67172

Parent Item: D500-572-011

Parent Item Name: Bearpaw

Start Date: 3/9/2011

Required Date: 3/16/2011

Start Qty: 2.00

Required Qty: 2.00

D2182B

Manufactured No

170 f

461.3681 1.666 3.332



Rubber Cushion



11/3/22

Location

Loc Qty

Loc Code

ST410

461.36811

63413

111.36811

66063

350

✓

Sx2 → measure
S w/ 1/2"

(D2182B050) cut 4 at 5.00"

D2274

Manufactured No

170 Each

484.0000



Radius Block



8 116
11/3/22

Location

Loc Qty

Loc Code

ST010

484

61361

1

63990

6

65562

104

65757

250

66123

123

16

Sx2

D2435

Manufactured No

170 Each

0.0000



Bearpaw, 206



2 4
67173

D2438

Manufactured No

170 Each

159.0000



Clamp



4 8
11/3/22

Location

Loc Qty

Loc Code

ST456

159

64772

25

66064

79

66128

55

2

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Shop Packet Print

Page 2

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Work Order ID: 67172

Parent Item: D500-572-011

Parent Item Name: Bearpaw

Start Date: 3/9/2011

Required Date: 3/16/2011

Start Qty: 2.00

Required Qty: 2.00

D2529
Washer

Manufactured No

170 Each

982.0000

8 16
11/3/22

Location

Loc Qty

Loc Code

ST016

982

64127

482

66953

500

16

MS21042L4
Nut

Purchased No

170 Each

4,376.000

8 16
11/3/22 sl 120

Location

Loc Qty

Loc Code

ST300

4376

1123143

2

115589

10

115621

20

116188

2344

116823

2000

10

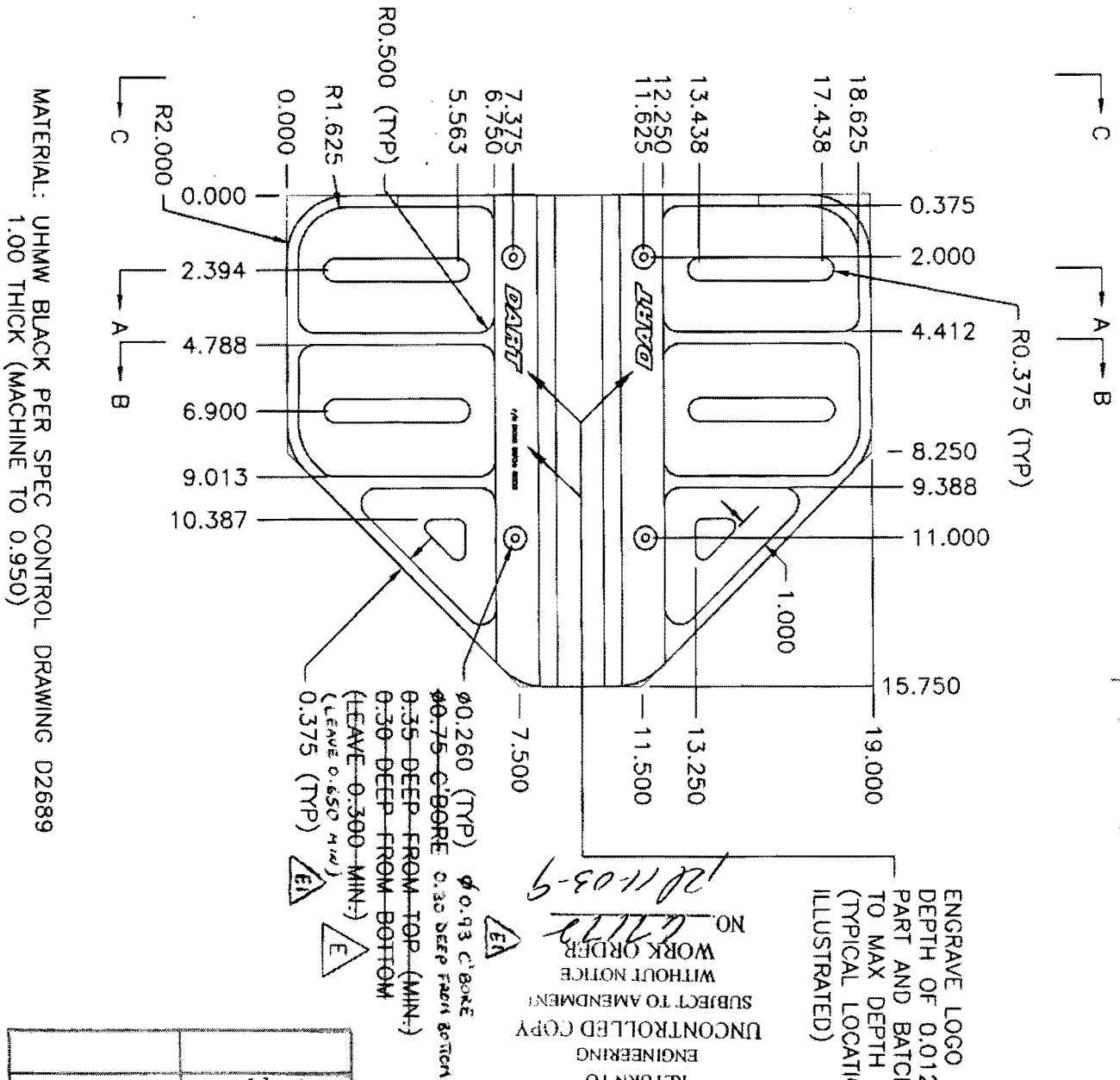
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ENGRAVE LOGO TO MAX
DEPTH OF 0.012. ENGRAVE
PART AND BATCH NUMBERS
TO MAX DEPTH OF 0.010.
(TYPICAL LOCATION AS
ILLUSTRATED)

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 22172

DART AEROSPACE LTD HAMKESBURY, ONTARIO, CANADA	REV. E	SHEET 1 OF 2	SCALE	1:5
DRAWING NO.	D2435	TITLE	BEARPAW	
CHECKED	APPROVED	DATE	98.05.19	
A	96.01.24	NEW ISSUE		
B	96.03.26	CHANGE BORE AND C'BORE DEPTH		
C	97.05.07	CHANNEL & C'BORE DEPTH CHANGED		
D	97.10.17	R1.5 BORE WAS R2.637 (TSR A469)		
E	98.05.19	CHANGE C'BORE, R1.58 WAS R1.50		

	5716

MATERIAL: UHMW BLACK PER SPEC CONTROL DRAWING D2689
1.00 THICK (MACHINE TO 0.950)

DART

RELEASE 48,06,17 KE

02:2:17 00:13 was 00:75

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

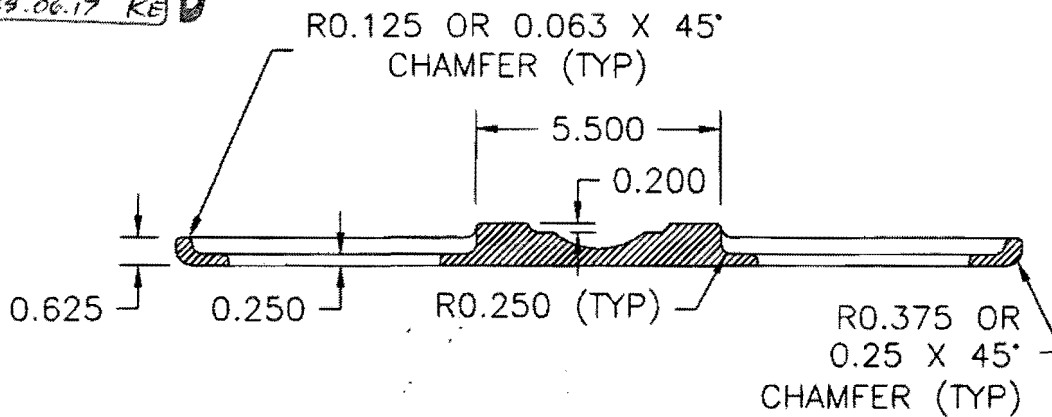
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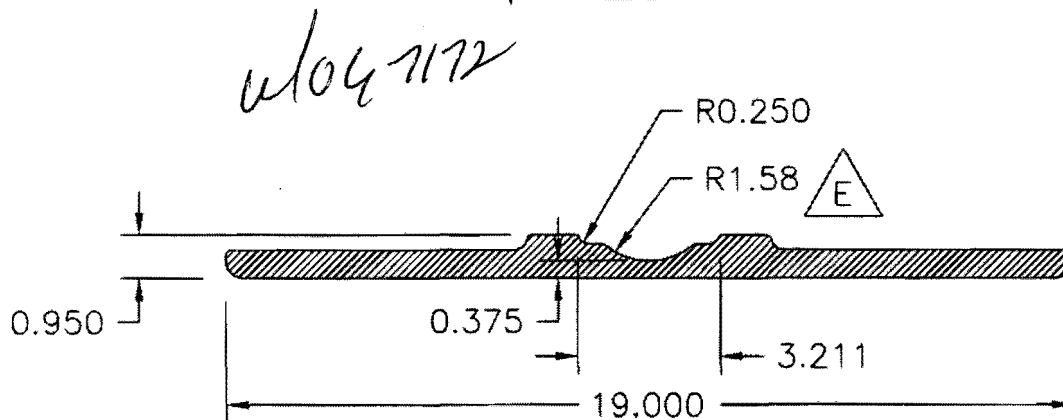


DESIGN <i>KE</i>	DRAWN BY <i>KE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>KE</i>	APPROVED <i>KE</i>	DRAWING NO. D2435	REV. E SHEET 2 OF 2
DATE 98.05.19		TITLE BEARPAW	SCALE 1:4

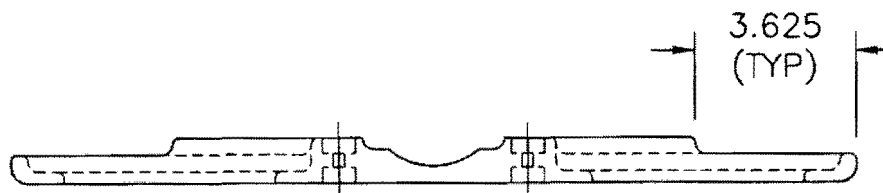
RELEASED
98.06.17 KE



SECTION A-A



SECTION B-B



SECTION C-C

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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REFERENCE ONLY

32.3 WEIGHT AND BALANCE

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D500-572-011 Bearpaw Installation	8.5 lb 3.86 kg	0.0 in 0.0 m	0.0 lb-kg 0.0 m-kg	130 in 3.30 m	1105 in-lb 12.74 m-kg
D500-572-021 Narrow Bearpaw Installation	7.5 lb 3.41 kg	0.0 in 0.0 m	0.0 lb-kg 0.0 m-kg	130 in 3.30 m	975 in-lb 11.25 m-kg
D500-572-013 Bearpaw Installation	11.4 lb 5.17 kg	0.0 in 0.0 m	0.0 lb-kg 0.0 m-kg	128 in 3.25 m	1459 in-lb 16.80 m-kg
D600-572-015 Bearpaw Installation	11.4 lb 5.17 kg	0.0 in 0.0 m	0.0 lb-kg 0.0 m-kg	122 in 3.10 m	1391 in-lb 16.03 m-kg

32.4 PARTS LIST

Qty D500 -572 -011	Qty D500 -572 -021	Qty D500 -572 -013	Qty D600 -572 -015	Part Number	Description
X				D500-572-011	BEARPAW INSTALLATION
	X			D500-572-021	NARROW BEARPAW INSTALLATION
		X		D500-572-013	BEARPAW INSTALLATION
			X	D600-572-015	BEARPAW INSTALLATION
2				D2435	BEARPAW
	2			D2671	BEARPAW
		2		D2995	BEARPAW
			2	D2996	BEARPAW
4	4	4		D2182B050	RUBBER CUSHION
			4	D2182B060	RUBBER CUSHION
8	8	8	8	D2274	RADIUS BLOCK
4	4	4		D2438	CLAMP
			4	D2519	CLAMP
8	8	8	8	D2529	WASHER
		8	8	AN4-13A	BOLT
8	8			AN4-15A	BOLT
8	8	8	8	AN960JD416	WASHER
8	8	8	8	MS21042L4	NUT (OR MS21042-4)
2	2			QS200M44S	CLAMP
			4	QS100M24S	CLAMP